

Work Order ID 59246

Friday, May 28, 2010 7:50:10 AM



Page 1

Item ID: D205-706-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 5/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D412-706

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-706-013

3 CHG002

8/2/05/71

JG BG 10/05/28

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

P 10/10/28 C

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/2/05/31

10

Work Order ID 59246

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Item ID: D205-706-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 5/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-706-013 Location: _____ PPP Rev: <u>D</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/05/31

10/05/31

MF
10-5-31

Picklist Print

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Page 1

Work Order ID: 59246

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister





Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC

Start Date: 5/28/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN3-5A  Bolt	Purchased		No			110	Each	941.0000	4	4			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST350		941					
						105057		941					
AN814-6D  Plug	Purchased		No			110	Each	12.0000	1	1			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST329		12					
						114742		12					
AN815-6D  Union-M-Flare	Purchased		No			110	Each	14.0000	2	2			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST329		14					
						114348		8					
						114523		5					
						M122966		1					
AN833-6D  Elbow, Bulkhead-M-Flare	Purchased		No			110	Each	16.0000	3	3			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST333		16					
						111650		16					

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Work Order ID: 59246

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister





Start Date: 5/28/2010

Required Date: 5/28/2010

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC
IPP Rev:F 10.05.10 as per

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN924-6D	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 110	Unit of Each	Qty on 24.0000	Qty per Kit 4	Total 4	Qty	Date	Status
													
Nut													
<div> <div>Location</div> <div>ST335</div> <div>111650</div> <div>114742</div> </div> <div> <div>Loc Qty</div> <div>24</div> <div>9</div> <div>15</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN960JD10 NAS1149D0363J		Purchased	No			110	Each	0.0000	8	18			
													
Washer													
AN960JD10L NAS1149D0332J		Purchased	No			110	Each	3,935.000	4	4			
													
Washer													
<div> <div>Location</div> <div>ST348</div> <div>110985</div> </div> <div> <div>Loc Qty</div> <div>3935</div> <div>3935</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN960JD916		Purchased	No			110	Each	22.0000	2	2			
													
WASHER													
<div> <div>Location</div> <div>ST348</div> <div>109174</div> </div> <div> <div>Loc Qty</div> <div>22</div> <div>22</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

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Work Order ID: 59246

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC

Start Date: 5/28/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00



Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty.per-Kit	Total	Qty	Date	Status
D2001-4		Manufactured	No			110	Each	9.0000	1	1			
Valve Assembly (1/4")													

Location	Loc Qty	Loc Code
ST002	9	
55525	3	
56682	6	

D3262-041		Manufactured	No			110	Each	3.0000	1	1			
Canister Assembly													

Location	Loc Qty	Loc Code
ST144	3	
55184	2	
55688	1	

D3264-1		Manufactured	No			110	Each	7.0000	2	2			
Bracket													

Location	Loc Qty	Loc Code
ST144	7	
55733	7	

D3297-1-0121		Manufactured	No			110	Each	4.0000	1	1			
HOSE ASS'Y													

Location	Loc Qty	Loc Code
ST194	4	
47419	2	
58004	2	

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Work Order ID: 59246



Parent Item: D205-706-013



Parent Item Name: Fuel Purge Canister

Start Date: 5/28/2010

Required Date: 5/28/2010

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC
IPP Rev:F 10.05.10 as per

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3297-1-0130		Manufactured	No			110	Each	4.0000	1	1			
HOSE ASS'Y													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST194		4							
				55069		4							
D3297-3-0350		Manufactured	No			110	Each	4.0000	1	1			
HOSE ASS'Y													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST194		4							
				58005		4							
D3298-001		Manufactured	No			110	Each	8.0000	1	1			
Tube Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST195		8							
				48507		8							
D3298-009		Manufactured	No			110	Each	11.0000	1	1			
Tube Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST195		11							
				47300		1							
				47506		10							

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Work Order ID: 59246



Parent Item: D205-706-013



Parent Item Name: Fuel Purge Canister

Start Date: 5/28/2010

Required Date: 5/28/2010

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC
IPP Rev:F 10.05.10 as per

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3299-1		Manufactured	No			110	Each	15.0000	1	1			
Fitting													

Location	Loc Qty	Loc Code
ST050	15	
42170	12	
55540	2	
57273	1	

D3299-3		Manufactured	No			110	Each	22.0000	1	1			
Fitting													

Location	Loc Qty	Loc Code
ST050	22	
42171	16	
55530	6	

D3301-1		Manufactured	No			110	Each	25.0000	1	1			
Placard													

Location	Loc Qty	Loc Code
ST050	25	
47422	1	
56601	12	
56685	12	

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Work Order ID: 59246

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister


Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC

Start Date: 5/28/2010

Required Date: 5/28/2010


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3301-3		Manufactured	No			110	Each	11.0000	1	1	✓		
													
Placard													


Location	Loc Qty	Loc Code
ST050	11	
47301	1	
47423	10	

47301

D3302-1		Manufactured	No			110	Each	5.0000	1	1	✓		
													
Doubler													

Location	Loc Qty	Loc Code
ST143	5	
47424	2	
54577	3	

47424

D3302-3		Manufactured	No			110	Each	13.0000	1	1	✓		
													
Doubler													

Location	Loc Qty	Loc Code
ST142	13	
54578	13	

54578

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Work Order ID: 59246

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC
IPP Rev:F 10.05.10 as per

Start Date: 5/28/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
MS21042L3		Purchased	No			110	Each	3,684.000	4	4			
Nut													

Location	Loc Qty	Loc Code
ST300	3684	
113537	20	
113644	164	
114523	1000	
114718	500	
114784	2000	

m113644

MS21919-WDG12	Purchased	No				110	Each	30.0000	1	1			
Clamp													

Location	Loc Qty	Loc Code
ST307	30	
107534	30	

m607537

MS21919-WDG16	Purchased	No				110	Each	14.0000	2	2			
Clamp													

Location	Loc Qty	Loc Code
ST307	14	
111548	4	
114523	10	

m111548

MS21919-WDG9	Purchased	No				110	Each	48.0000	5	5			
Clamp													

Location	Loc Qty	Loc Code
ST307	48	
111578	48	

m111578

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Work Order ID: 59246

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister


Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM
chg002 DD verified :EC

Start Date: 5/28/2010

Required Date: 5/28/2010


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
MS21920-42		Purchased	No			110	Each	6.0000	2	2			
													
CLAMP(per MIL-DTL-8783C)													


Location Loc Qty Loc Code

ST451 6
114113 6

MS28778-6		Purchased	No			110	Each	38.0000	5	5			
													
Packing													

Location Loc Qty Loc Code

ST294 38
112966 8
113422 20
114494 10

MS35489-11		Purchased	No			110	Each	24.0000	1	1			
													
GROMMET													

Location Loc Qty Loc Code

ST295 24
109166 24

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5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
1	1	1	D3262-041	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0085	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
1	1		D3298-001	TUBE ASSEMBLY
1			D3298-003	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
1	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
1	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
4	4	4	AN3-5A	BOLT
1	1	1	AN814-6D	PLUG
3	2	2	AN815-6D	UNION
		1	AN816-6D	NIPPLE
1			AN832-6D	UNION
2	3	1	AN833-6D	ELBOW
		1	AN919-6D	REDUCER
5	4	1	AN924-6D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER

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Revision: A

Date: 04.11.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

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2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
10	5	5	MS28778-6	O-RING
1	1	1	MS35489-11	GROMMET

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Revision: A

Date: 04.11.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries